

**Work Order ID 60864**

Monday, July 26, 2010 11:42:52 AM

Page 1

Item ID: D3535-23

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 7/26/2010 Start Qty: 10.00

Required Date: 8/3/2010 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535

☐ Dwg Rev:☐ Prog Rev:

Deburr if necessary

304 .040

110

0.00

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

120

0.00

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

S10/08/03

(10)

B10-7-07

10-07-07

B10-7-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 60864**

Monday, July 26, 2010 11:42:52 AM



Page 2

Item ID: D3535-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 7/26/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 2-Form  
joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-23

*JS 10/28/09* (Signature)

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*JS 10/08/09*

(Signature)

150

0.00



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:00pm ☐ OVEN TEMPERATURE:  
1:30pm ☐ FINISH TIME: 3:20pm

*1112588*

*JS 10/08/11*

*x10 9*

W/O:		WORK ORDER CHANGES					
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**Work Order ID 60864**

Monday, July 26, 2010 11:42:52 AM

Page 3

Item ID: D3535-23

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearshoe

Start Date: 7/26/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 10.00

Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				ml	10	08	11 (10)
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-21</u>  Memo	0.00  0.00		44	10/08/11	110	Ø		
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							10/08/12 mf 10-8-11

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, July 26, 2010 11:42:57 AM

Page 1

Work Order ID: 60864



Parent Item: D3535-23



Parent Item Name: Wearshoe

Start Date: 7/26/2010

Required Date: 8/3/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	51.8987	1.3615	14.33158			



304/316 .040 Sheet



1810-7-27

Location

Loc Qty

Loc Code

MAT

48.4522

114574

48.4522

MAT20

3.4465

112885

2.7475

113062

0.699

114574

10

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	60869
<b>Description:</b> Wearshoe		<b>Part Number:</b>	D3535-23
<b>Inspection Dwg:</b> D3535 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.885	✓		V B02	
2.000	+/-0.010	2.000	✓		V H	
4.750	+/-0.010	4.750	✓		T B01	
9.500	+/-0.010	9.500	✓		T	
14.250	+/-0.010	14.250	✓		T	
17.750	+/-0.010	17.750	✓		T	
23.140	+/-0.010	23.140	✓		T	
28.530	+/-0.010	28.530	✓		T	
33.920	+/-0.010	33.920	✓		T	
39.310	+/-0.010	39.310	✓		T	
44.700	+/-0.010	44.700	✓		T	
48.200	+/-0.010	48.200	✓		T	
52.850	+/-0.010	52.850	✓		T	
Ø0.188	+0.005/-0.001	0.192	✗		V	
48.00	+/-0.030	48.00	✗		T	
39.00	+/-0.030	39.00	✗		T	
32.00	+/-0.030	32.00	✗		T	
24.00	+/-0.030	24.00	✓		T	
16.00	+/-0.030	16.00	✓		T	
8.00	+/-0.030	8.00	✓		T	
6.00	+/-0.030	6.00	✓		T	
0.300	+/-0.010	0.304	✗		V	
0.300	+/-0.010	0.303	✗		V	
0.038	+/-0.010	0.035	✗		V	

<b>Measured by:</b>	B	<b>Audited by:</b>	S	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	10-7-27	<b>Date:</b>	10/08/03	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	

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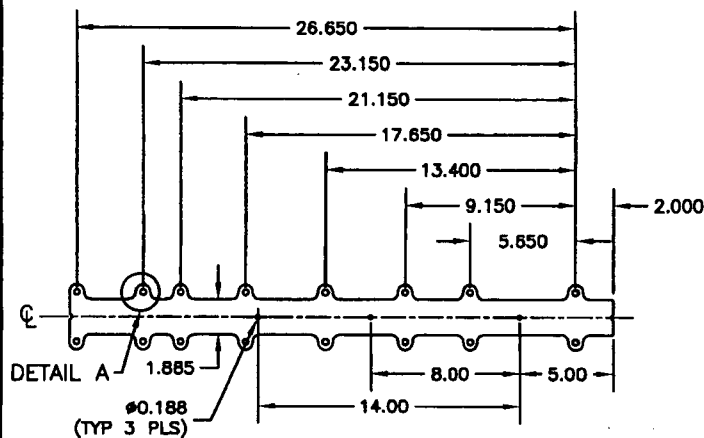
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**DART**

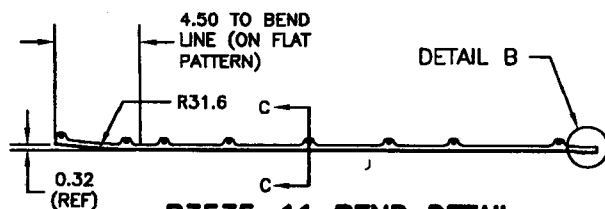
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07.04.24

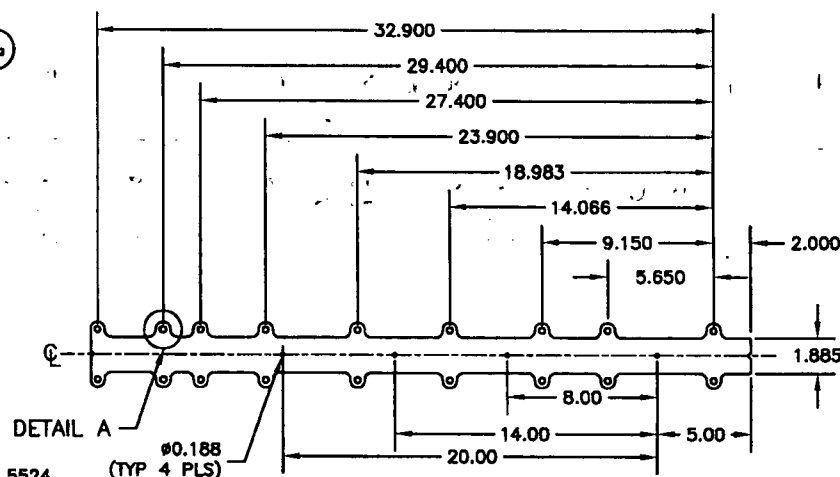
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UNCONTROLLED COPY  
SUBJECT TO A REVISION  
WITHIN THE  
WORK ORDER  
NO. 60864  
PS10-7-26



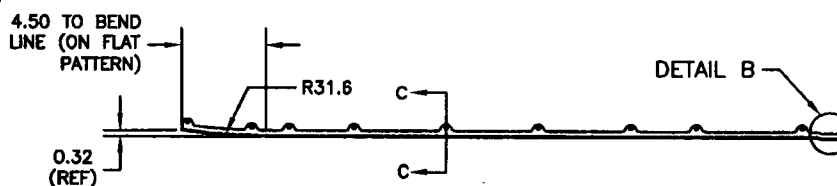
**D3535-11F FLAT PATTERN**



**D3535-11 BEND DETAIL**



**D3535-13F FLAT PATTERN**



**D3535-13 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D3535	SHEET 1 OF 7	
DATE	TITLE	SCALE		
07.04.17	WEARSHOE	1:10		
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

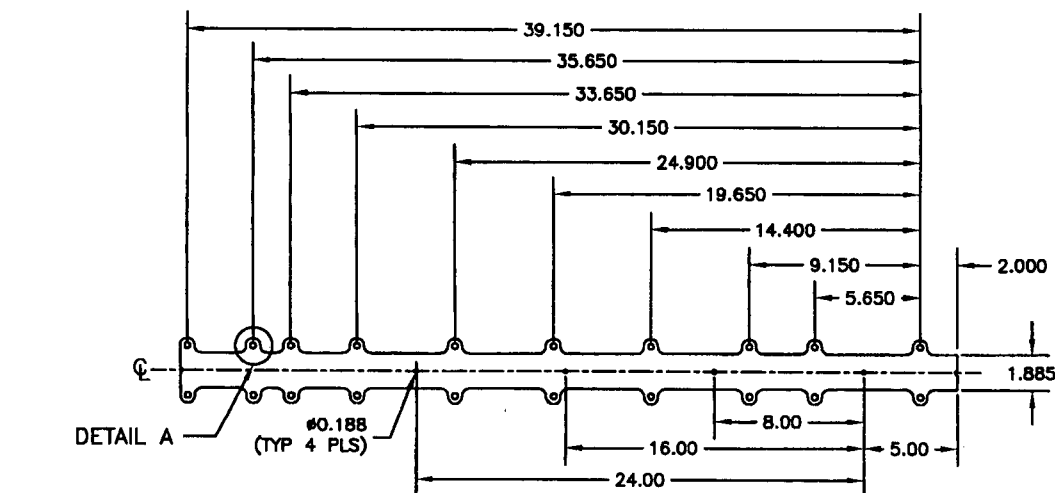
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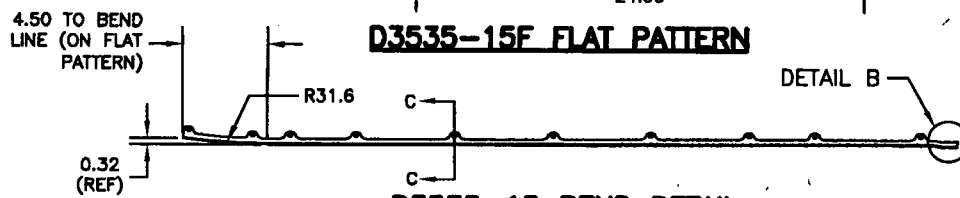
07.04.24

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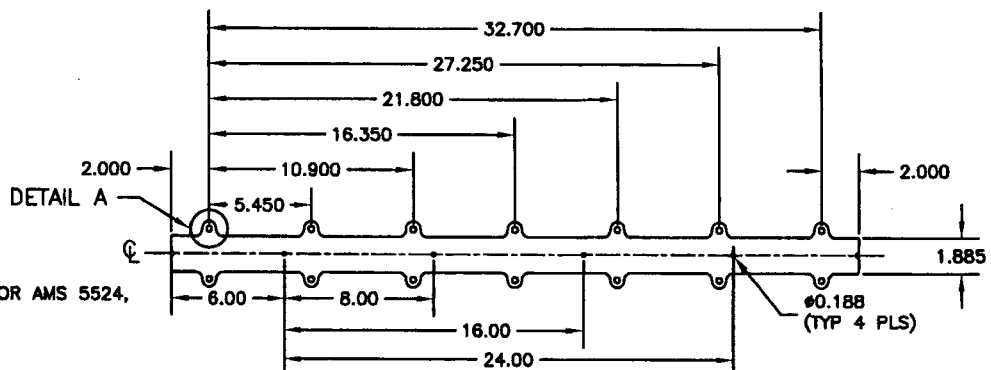
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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	SHEET 2 OF 7
07.04.17	WEARSHOE	SCALE 1:10



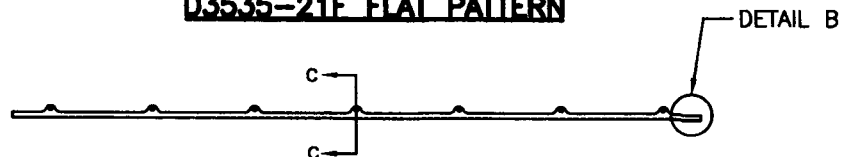
**D3535-15F FLAT PATTERN**



**D3535-15 BEND DETAIL**



**D3535-21F FLAT PATTERN**



**D3535-21 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
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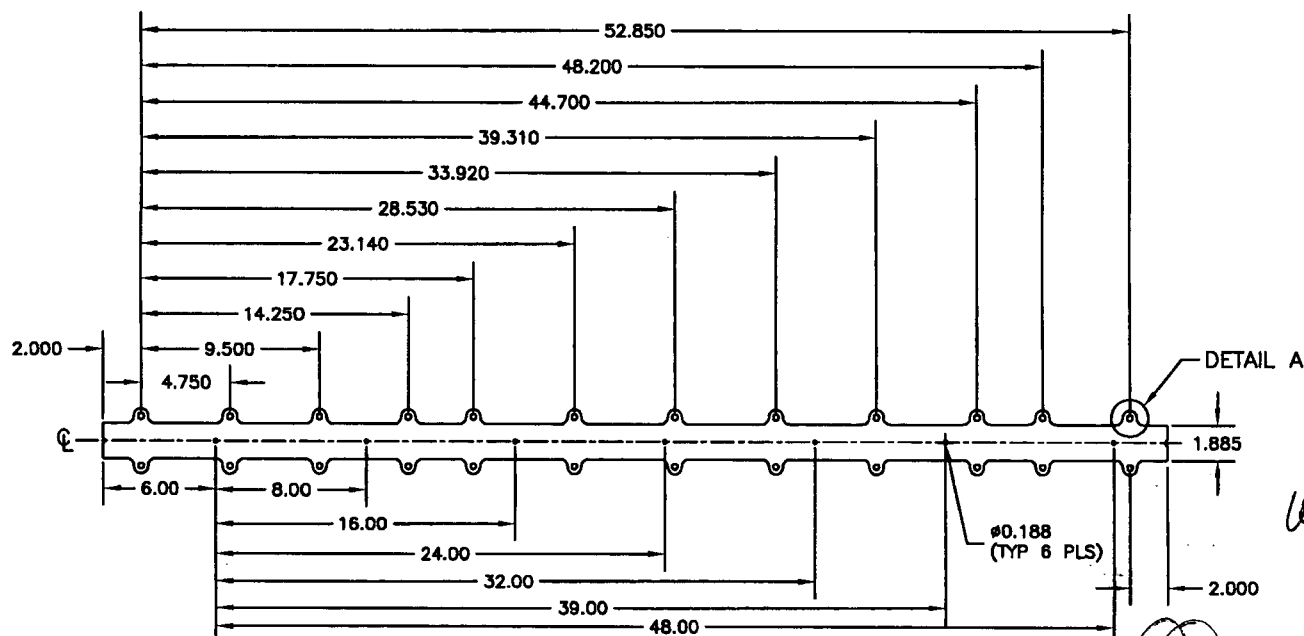
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**DART**

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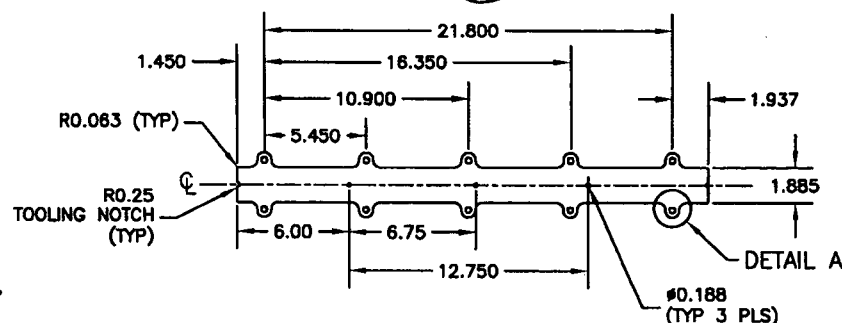
07.04.24

W/O 60864



**D3535-23F FLAT PATTERN**

**D3535-23 BEND DETAIL**



**D3535-25F FLAT PATTERN**

**D3535-25 BEND DETAIL**

**NOTES**

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	SHEET 3 OF 7
07.04.17	WEARSHOE	SCALE 1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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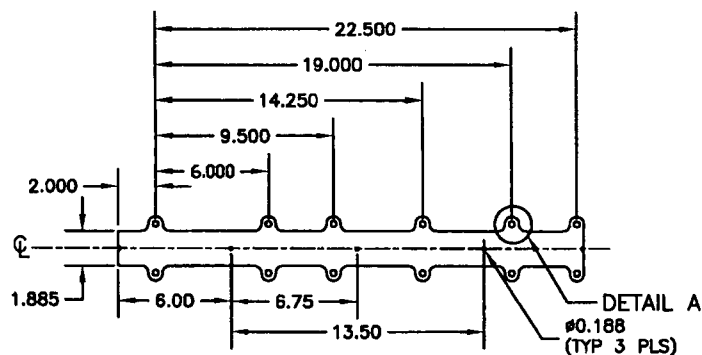
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07.04.24

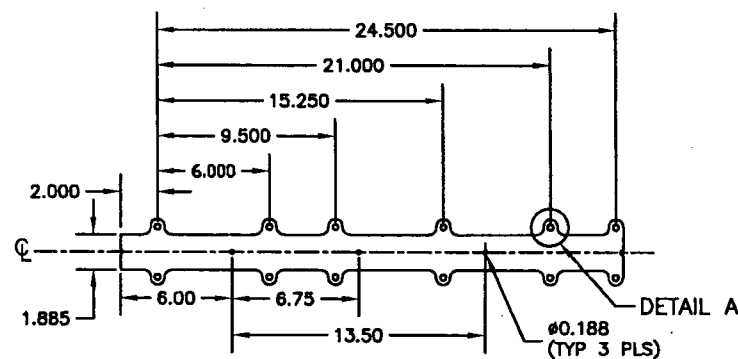


**D3535-31F FLAT PATTERN**



**D3535-31 BEND DETAIL**

*who 60864*



**D3535-33F FLAT PATTERN**



**D3535-33 BEND DETAIL**

**NOTES**

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(REF DART SPEC M304S20GA)
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<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 4 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

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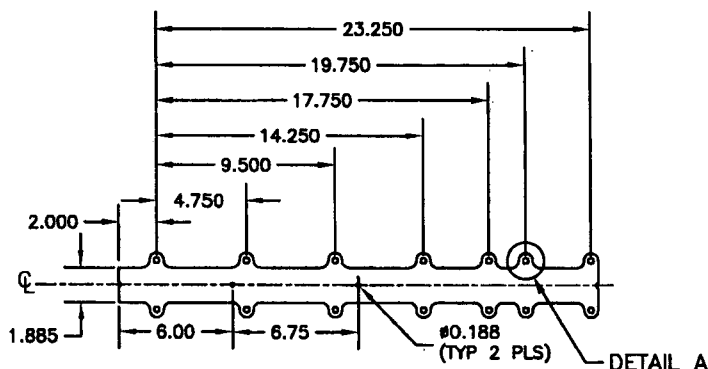
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07.04.24

W/C 60864

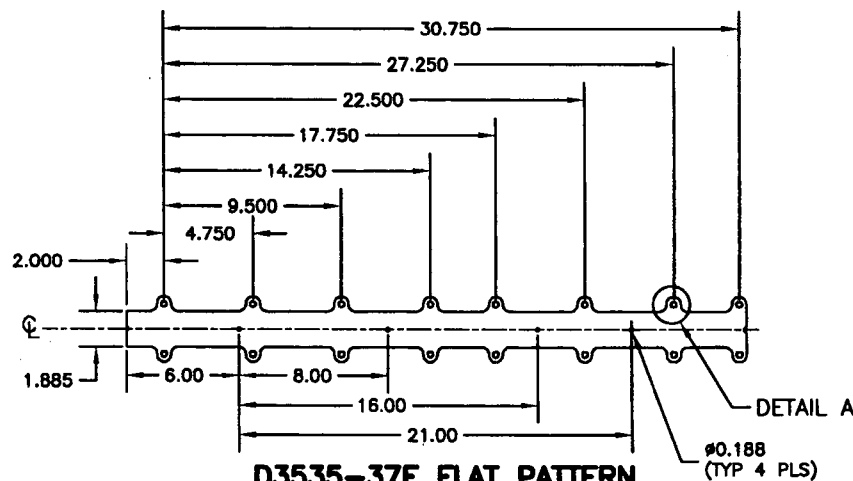
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
				REVISION
				SHEET 5 OF 7
				SCALE
				1:10



**D3535-35F FLAT PATTERN**



**D3535-35 BEND DETAIL**



**D3535-37F FLAT PATTERN**



**D3535-37 BEND DETAIL**

**NOTES**

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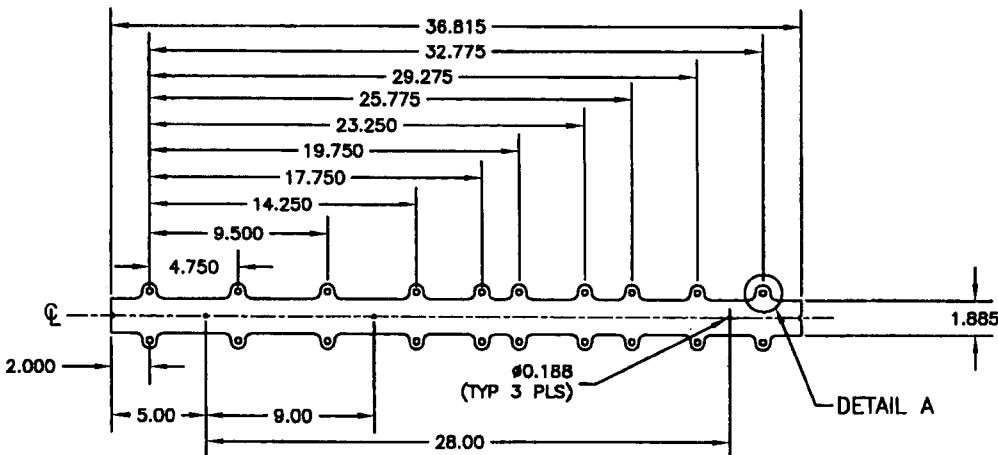
**NOTE:** Date & initial all entries

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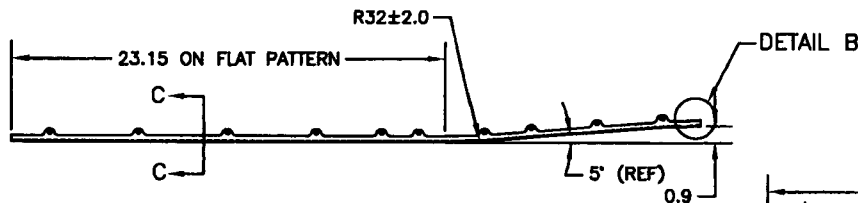
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07.04.24

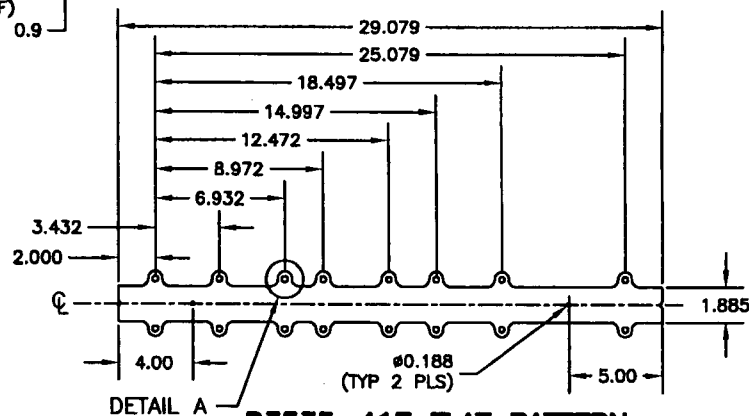
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CB	AM	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 6 OF 7
		SCALE 1:10



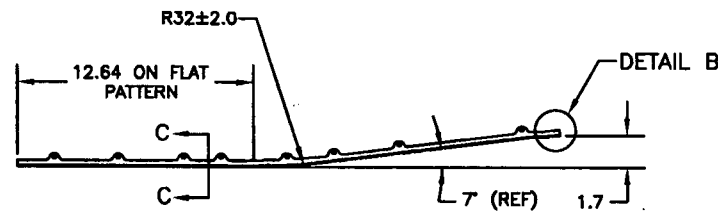
**D3535-39F FLAT PATTERN**



**D3535-39 BEND DETAIL**



**D3535-41F FLAT PATTERN**



**D3535-41 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

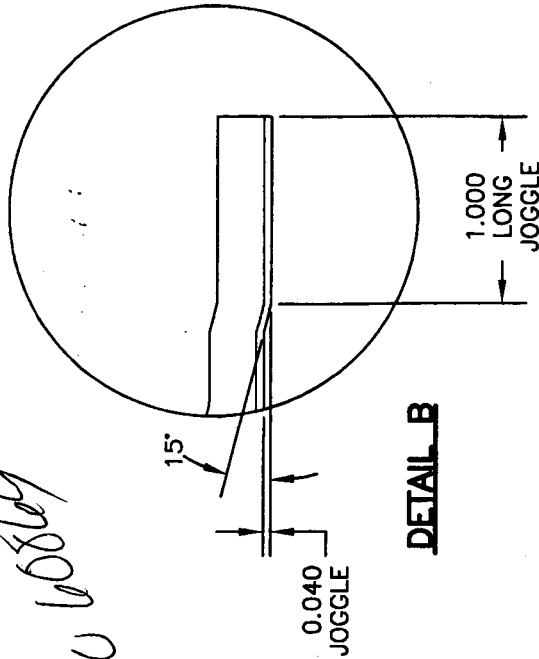
**NOTE:** Date & initial all entries



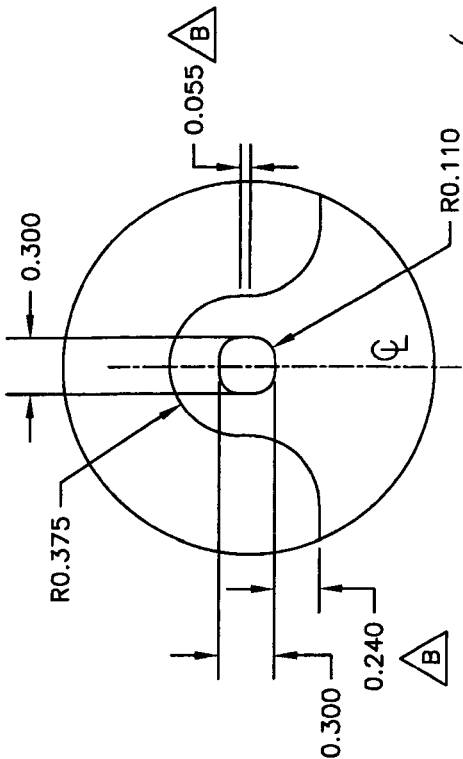
DESIGN <b>CB</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED

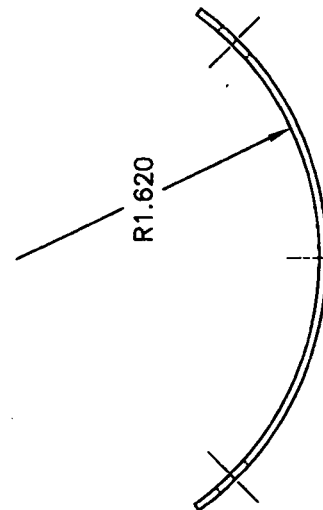
07.04.24 *[Signature]*



**DETAIL B**



**DETAIL A**



**SECTION C-C**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries